Work Order ID 111982

January-28-14 10:03:48 AM

111982

Item ID: D5022-5 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: Foam, Side Panel, Aft **Stop** *NS2*

Start Date: 03/02/2014 **Start Qty:** 4.00 *4*

Required Date: 03/02/2014 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** [signature] **Date:** 14-01-28 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D5022	B								
110		0.00							
110						4	0		JM14-02-6
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						4	0		JM14-02-6
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D5022-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Foam, Side Panel, Aft
Start Date: 03/02/2014 **Start Qty:** 4.00 *4*
Required Date: 03/02/2014 **Req'd Qty:** 4.00 *4*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00 DAS 27 9-89				4			
130									
QC	**Memo**	0.00 14/2/6							
Quality Control									
140	Identify as per dwg & Stock Location: mecl Fab	0.00				(4)	SAD 14/02/11		
140									
Packaging	**Memo**	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00				MLJ 14-02-11			
150									
QC	**Memo**	0.00				(4) 14.02-11			
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

January-28-14 10:03:47 AM

Work Order ID: 111982

Parent Item: D5022-5 **Start Date:** 03/02/2014 **Required Date:** 03/02/2014

Parent Item Name: Foam, Side Panel, Aft **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM IPP REV B 14/01/09 QTY CHANGE MAT. D5033-1 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5033-1 Rigid Polyurethane Foam		Manufactured	No				sf	64.0000		22			

Location	Loc Qty	Loc Code
MAT019	64	
110489	64	

111972

111972

Jm 14-02-06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Heat Treat
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☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Misread
☐ Off-set
☐ Out of Calibration
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☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	111982
Description: FOAM.	Part Number:	D5022-5
Inspection Dwg: D5022 Rev: B		Page 1 of 1

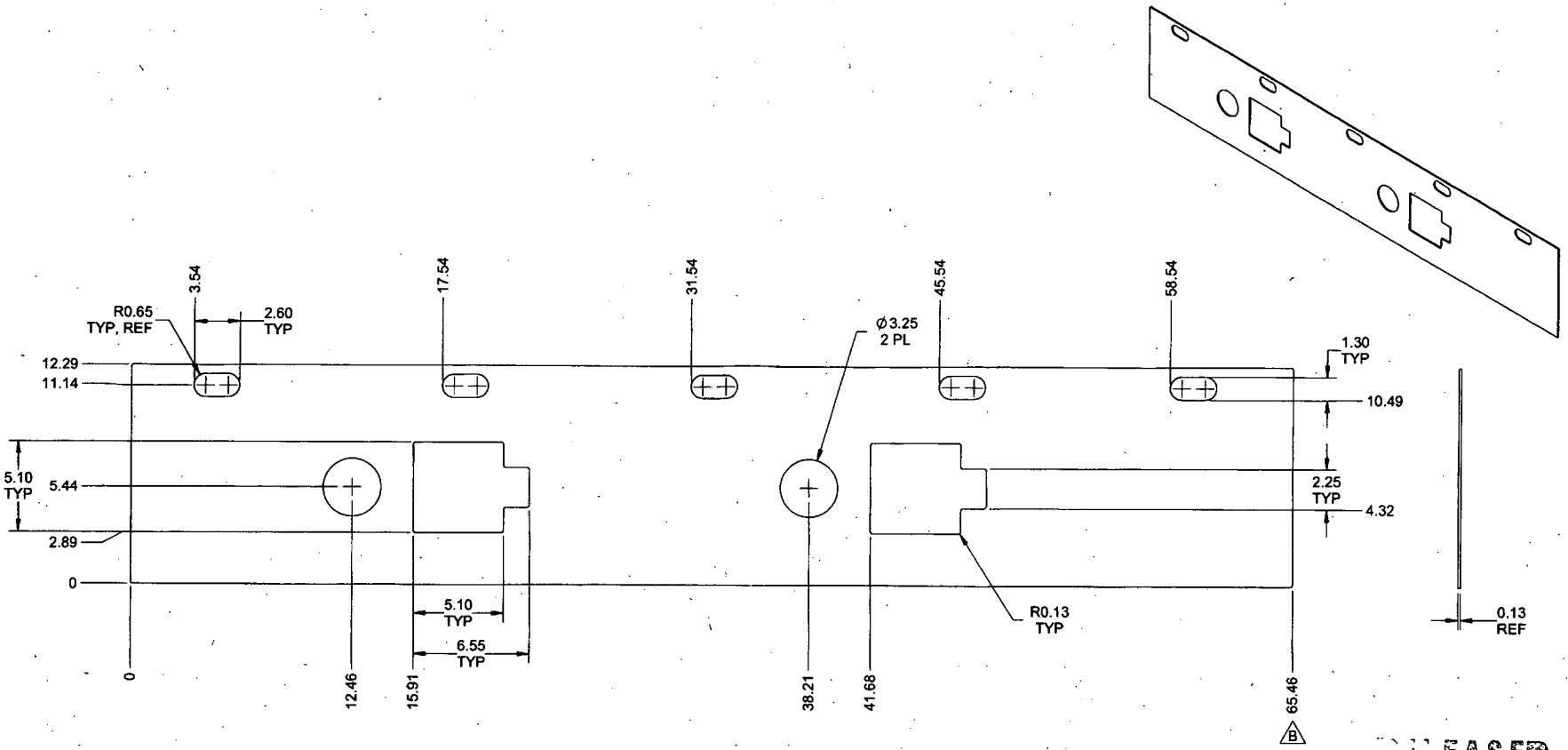
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.25"	+0.012" -0.001"	3.255"	–		V	JKmo1
5.19"	+/-0.030"	5.19"	–		V	
5.44"	"	5.44"	–		V	
7.26"	"	7.26"	–		V	
1.76"	"	1.76"	–		V	
11.14"	"	11.14"	–		T	JKmo6
12.29"	"	12.29"	–		T	
2.36"	"	2.360"	–		V	
2.60"	"	2.600"	–		V	
3.50"	"	3.50"	–		V	
19.36"	"	19.36"	–		T	
34.36"	"	34.36"	–		T	
1.30"	"	1.30"	–		V	
10.49"	"	10.49"	–		T	
5.10"	"	5.10"	–		V	
2.25"	"	2.25"	–		V	
1.43"	"	1.43"	–		V	
6.41"	"	6.41"	–		V	
4.50"	"	4.50"	–		V	
20.36"	"	20.36"	–		T	
23.81"	"	23.81"	–		T	
39.82"	"	39.82"	–		T	
6.45"	"	6.45"	–		V	

Measured by:	JM	Audited by:	~~DAS~~ 27	Preliminary Approval:	
Date:	14-02-6	Date:	14/2/16	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



RELEASED
2014-01-22

D5022-1 FOAM, SIDE PANEL, FWD

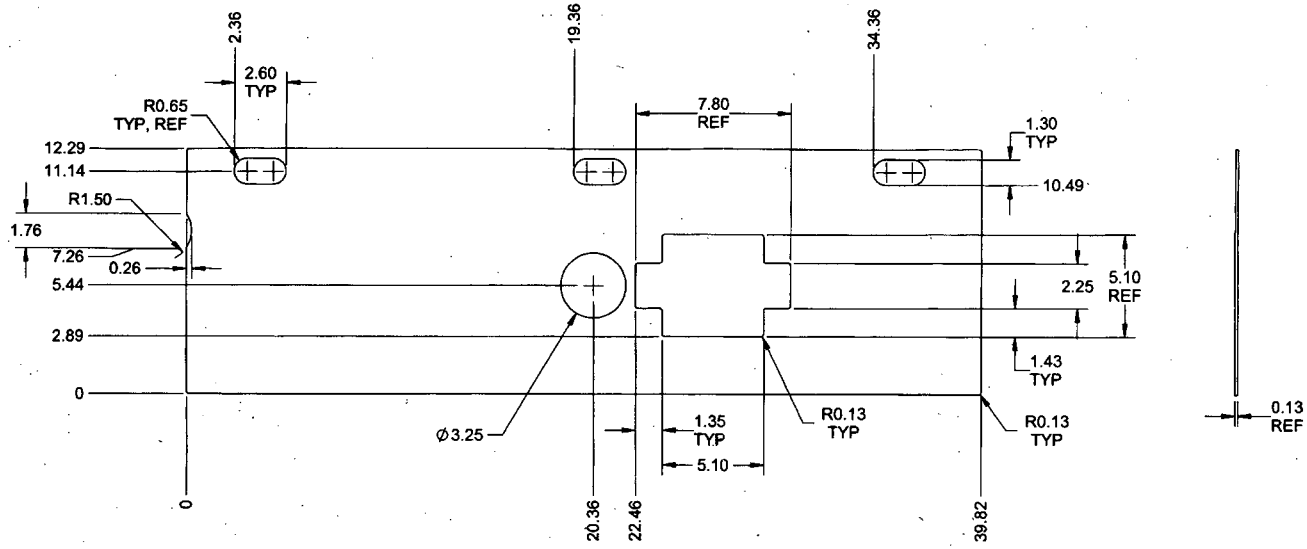
111982
14.02.28

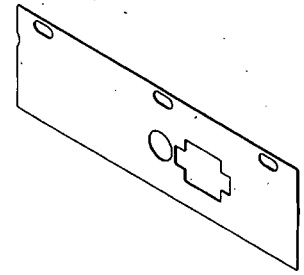
NOTES:
1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

REV.	DESCRIPTION	BY	DATE
B	65.46 WAS 65.59 (ZN B2-1)	RF	14.01.09
A	NEW ISSUE	RF	13.12.09

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D5022 REV. B
MFG. APPR.		SHEET 1 OF 3
APPROVED		TITLE FOAM CORE SCALE NTS
DE APPR.		
DATE	14.01.09	

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RELEASED
2014 -01- 22

D5022-3 FOAM, SIDE PANEL, AFT, LH

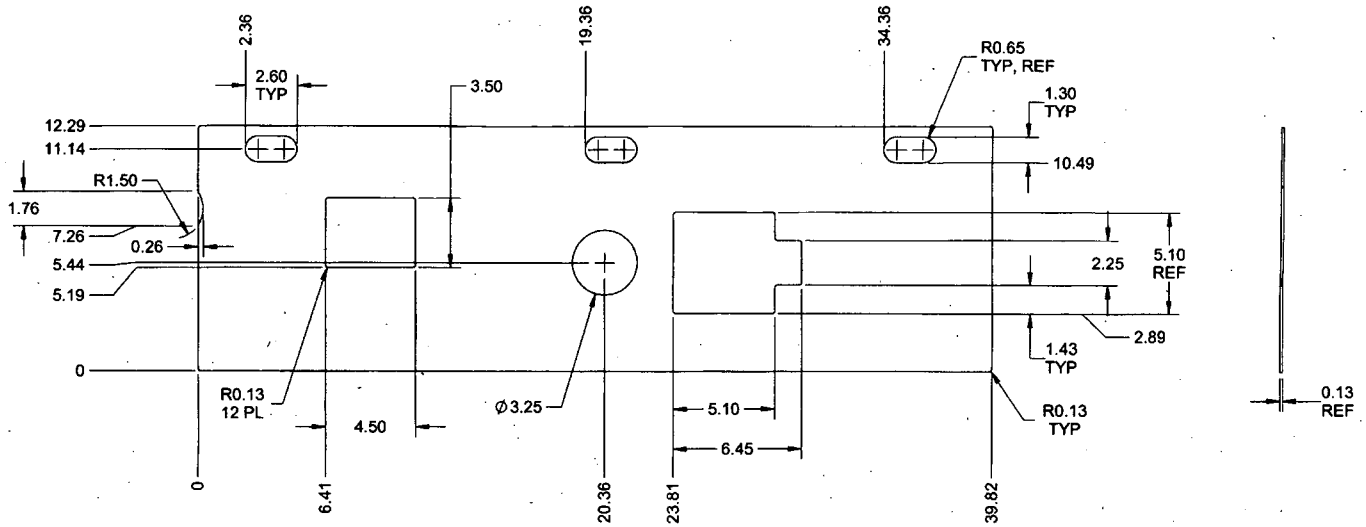
NOTES:
1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.19 lbs

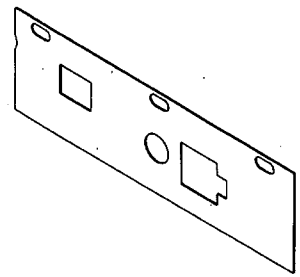
DESIGN	RF
DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	14.01.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5022 REV. B
SHEET 2 OF 3
TITLE FOAM CORE
SCALE NTS

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D5022-5 FOAM, SIDE PANEL, AFT, RH

RELEASED
2014 -01- 22

NOTES:
1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.19 lbs

DESIGN	RF
DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	14.01.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5022 REV. B
SHEET 3 OF 3
TITLE. FOAM CORE
SCALE NTS

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